

Work Order ID 84199

84199

Page 1

May-07-12 11:22:50 AM

Item ID: D2274

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Radius Block

Start Date: 07/05/2012 Start Qty: 200.00

200

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 12/05/07 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2274

Rev F

100

0.00

100

SHEAR

Shear

Memo

0.00

Shear

blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2274

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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May 07-12 11:22:50 AM

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Accept

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Setup Start *NS1*

Revision ID:

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Item Name: Radius Block

Start Date: 07/05/2012 Start Qty: 200.00

200

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 12-05-23

130

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

TumbleDeburr any rough edges after tumbling

251

0

Jm

12-5-23

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

251

7/6/12-5-29

W/O:		WORK ORDER CHANGES					
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Quality Control

~~251 x 6 Mn103/29~~

251x. _____ 8p
12-5-25

12/5/30 *[Signature]*
MUE
12-05-30

W/O:		WORK ORDER CHANGES					
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Picklist Print

May-07-12 11:22:54 AM

Page 1

Work Order ID: 84199

84199

Parent Item: D2274

D2274

Parent Item Name: Radius Block

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP H00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	52.8030	0.0916	19.28421			

M6061T6B00750X00 125

6061-T6 Bar .750 x .125

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT001	11.168	
116406	2.75	
117653	8.418	
MAT003	41.635	
→ 119653	18.9	
120603	22.735	

18.9

OK 12/05/22

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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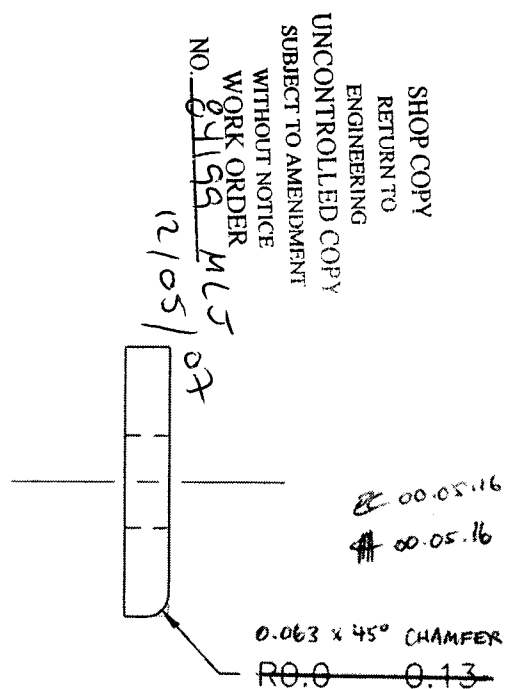
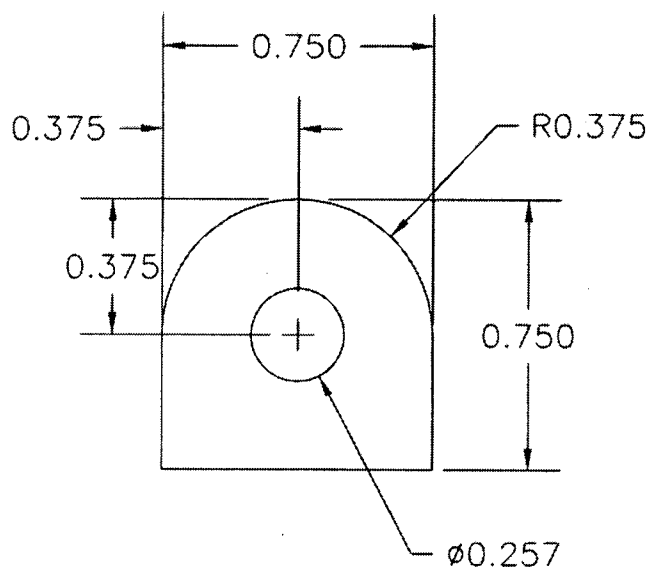
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/19 KE



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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